

Work Order ID 53890

November 23, 2009 11:24:40 AM

Page 1

Item ID: D2322

Accept

Setup Start

Revision ID: C

Stop

Item Name: Step Spacer

Start Date: 23/11/2009 Start Qty: 20.00

Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2322

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2322 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

B 9-12-2

58

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-12-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 80% 12/13

100%
7-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Step Spacer

Start Date: 23/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D2322	0.00 0.00				28	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SB 09/12/07					
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		MD 09/12/07		X28 X100			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00
10/09-12-7

28

2



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 6-A

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/07 28

09/12/08 MF 09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 11:24:47 AM

Page 1

Work Order ID: 53890



Parent Item: D2322RevC



Parent Item Name: Step Spacer

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

555.4571

4.2737

6.



11-26

2024-T3 .040 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

555.4570789

110305

192

110337

6.4

111786

32.0665789

112291

50.1264

112331

82.8641

113162

192

113162

W/O:		WORK ORDER CHANGES					
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DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29	TITLE STEP SPACER	SCALE 1:2	
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

RELEASED
98.10.08 DS

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JTB BEFORE MANUFACTURE

OK CP 04.11.99

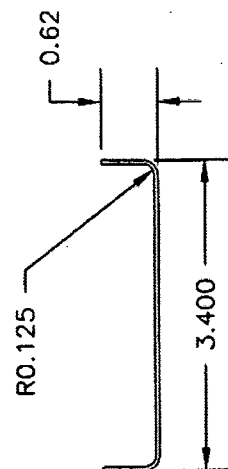
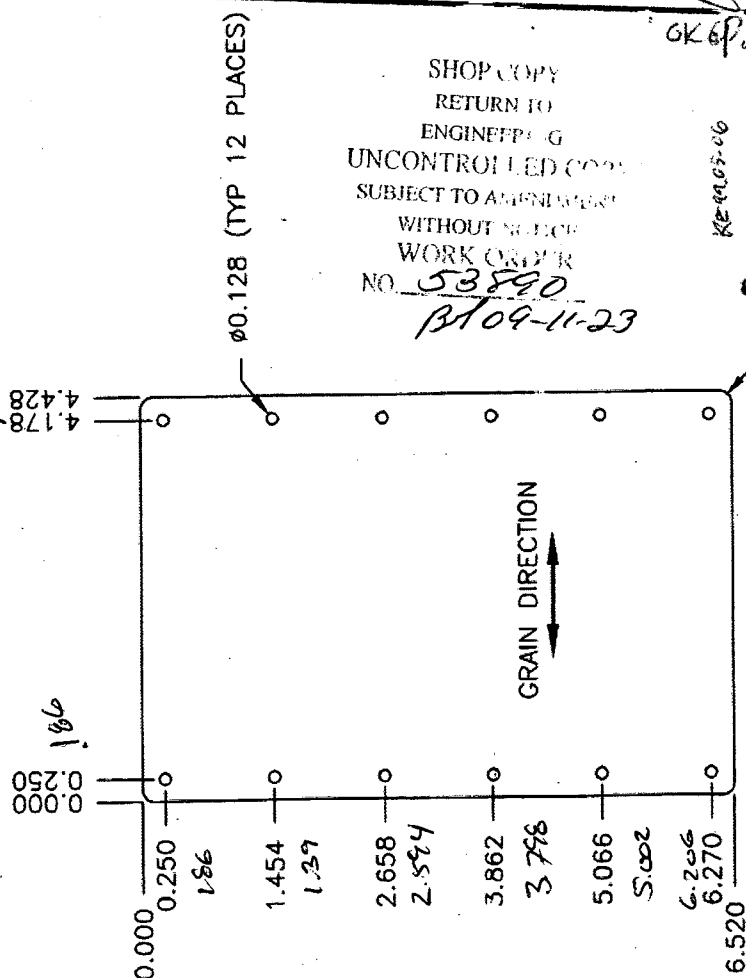
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 53590
B109-11-23

RE 01.03.06

R0.125
(TYP 4 PLACES)

FLAT LAYOUT

GRAIN DIRECTION
↑



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED